	er ID 976:	59		*976			Page 1		
tem ID: Revision ID: tem Name:	D3914-1		Accept *N90			<u>04010</u>	)O*	Setup Start	14.21
Start Date: Required Date: Reference:	2/22/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D:			141.17
Approvals:	Process Plan	:	Date:/3-02-2	/ Tooling:	Da	te:		Run Start Stop	*NR1*
	QC:		Date:	_ SPC (Y/N):	Da	te:		Stop	*NR2*
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan		Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revis	ion Nbr					101	,	11/2 4
D3914	В			·			/0x		1/4/3-02
00				0.00				•	
*100* Large Fab		Memo		0.00					
Large Fab			as per dwg D3914 d remove identification m	arkings	* •				•
110		QC6- Inspect dimension:	s to drawing	0.00			10	•	11/10
*110* QC Quality Control		Memo		0.00	*		10×		JM 13.05
120		Identify as per dwg & St	ock Location:	0.00				J.	
*170* Packaging Packaging	·	Basket Memo		0.00		·	10.		( <u>/</u> 1/3/05 <u>0</u>

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-CONFORMANCE / UPDATE					Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is		Skid-tube Crosstube Small Fab Thermoforming Finishing			Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No		<u>.</u>			Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		-
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material	_										
Setup	_										
Other	_										
Process	_				•	1					
Supplier											

	FAULT CATEGORY											
Landing	Gear	General		,								
	Bending	Bend		Grain		Ovalized		Pressure/Forced				
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure				
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	<u></u>	Weld				
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled				
	Cuffs	Contamination		Maintenance		Part Moved						
	Heat Treat	Countersink		Mislabeled		Positioned Wrong						
Γ	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other				
	Ripples in Bend	Drill Holes		Offset -								
	Torque Waves in Extrusion	Drawing		Out of Calibration								
	Turning Sequence	Finish		Out of Sequence								
	Wave/Twist in Tube	Folio		Outside Dimensions								

Training Unapproved

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Work Orde February-21-13				*976				Page 2	2			
Item ID: Revision ID: Item Name:	D3914-1			Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Sta	I	S1* S2*	
Start Date: 2/22/13 Star		Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*	Cust Item ID: Customer:							<b>3</b> /	
Approvals:			Date:	Tooling: SPC (Y/N):		ate:		R	Run Sta Sto		R1*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*130 *130* QC		QC21- Final Inspection	- Work Order Release	0.00				M	L <u>5</u>	13-05	- 06	-

Quality Control

N3-05-3.

											DQA	: Da	te:	
NCR: Y	'es	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPDATE	04.61			
											QA Closed	i: Da	te:	
Nork Orde	r:						DISPOSITION			AGAINST D	EPARTMEN	T/PROCESS		
Part N	io.						Rework Scrap Use-as-is			Skid-tube Crosstube  Machining Small Fab  noforming Finishing		Water Jet od. Eng. Coor. ore/Packaging		Engineering Quality Other
NCR N	lo.				<u> </u>		Work Order Update	]		Large Fab Composite	_	Supplier	l	
Root					Des	crip	otion of work order update	Ī	nitial	Action	Sign &	\		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Description	Date	Verificatio	n	QC Inspector
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Landir	ng G	iear	•				General	•						, ,
,		Bending					Bend		Grain		Ovalized		Pr	essure/Forced .
		Centre No	t Concer	ntric to (	o/s		BOM/Route	Г	Hardwa	are	Over/Unde	er tolerance	T€	emperature/Cure
		Cracks		;			Broken/Damaged		Inspect	ion Incomplete	Part Incorr	ect	N	'eld
		Crushed/C	Crimped.				Burrs	$\Box$	Instruct	tions Incomplete/Unclear	Part Lost/i	Missing	Πw	rong Stock Pulled
Ì		Cuffs	·				Contamination		Mainte	enance	Part Move	d		
Ì		Heat Treat	t				Countersink		Mislabe	eled	Positioned	Wrong		
ļ	Inspection Strip in Tube Cut Too Short					Cut Too Short		Misread	d T	Power Los		<u> </u>	ther	
Ripples in Bend Drill Holes							Drill Holes		Offset					
<b>├</b> ─ <b>┤</b>							Drawing -		Out of	Cálibration				
ļ	_	Turning Se					Finish		Out of	Sequence	<del></del>			
1	_	Wave/Twi		ie :	:		Folio		Outside	Dimensions				

February-21-13 12:39:26 PM

Work Order ID:

97659

Parent Item:

D3914-1

Parent Item Name:

Rib

**Start Date: 2/22/13** 

Required Date: 3/08/13

Start Qty: 2.00

Required Qty: 2.00

**Comments:** 

IPP Rev:A new issue DD 10.03.19 verified by:EC

IPP Rev:B as per dwg revB DD

	10.08.18 verified b	y:EC IF	PP Rev:C 11	.01.18 chg qc	5 to 6 DD v	erf:EC							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049	· · · · · · · · · · · · · · · · · · ·	Purchased	No			100	f	1,013.2474	. 8	16.842105	•		
304 SQ Tube .75x.75x.04	9W								¢		<del></del>		
			·	<b>Location</b>		Loc Qty	Lo	c Code					
				MAT017		566.3158				<del>.</del>			
				1244	192	566.3158							
				WA006		446.9315594							
				1232	219	64.5285735							
				1234	184	382.402986					/		1
			·	A S					81	195	10	X /	JL/3-0

125/24

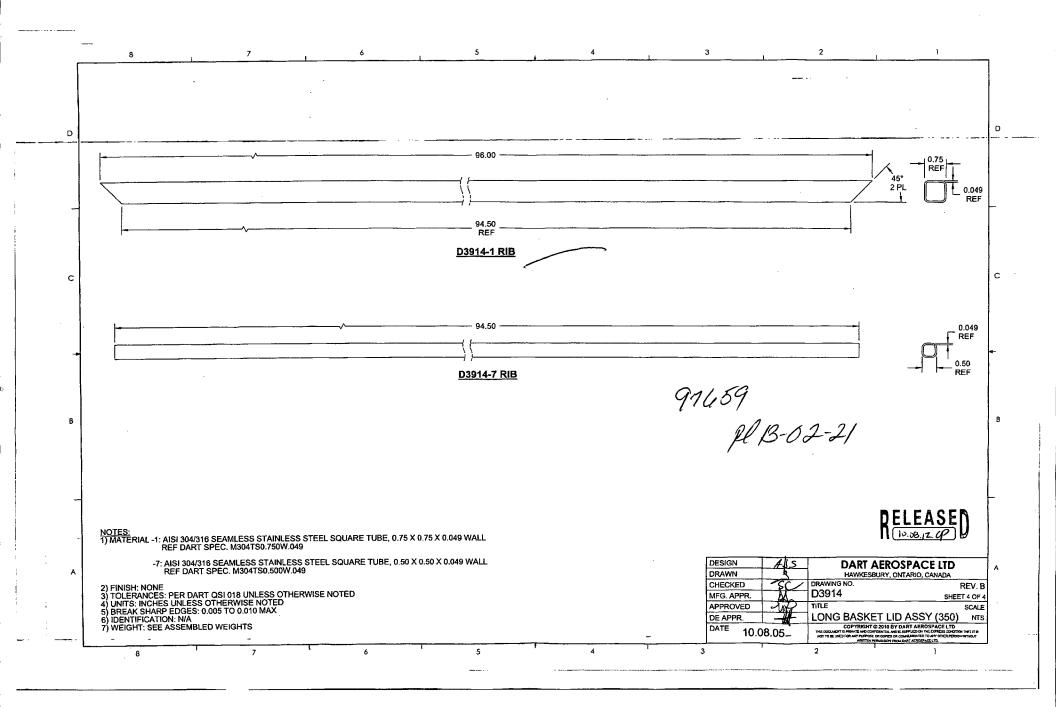
04.20

		DQA:	Date:	
ICD: Van / Na	WORK OPDER NON-CONFORMANCE / LIPDATE			

NCR: Yes	/ No				WORK ORDER NON-	COL	NFORM	MANCE / UF	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root	Data	Ston	Oty		ption of work order update or Non-conformance	1	nitial iief Eng		ction cription	Sign & Date	Verification	QC Inspector
Cause Doc/Data	Date	Step	Qty		of Non-comormance	1011	ilei Liig	003	cription	Dute	Vermedicit	QO MAPOOLO!
Equip/Tooling						İ		:			,	
Operator										i i		
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Setup								·				
Other		l						•				
Process								·				
Supplier		}										
Training												
Unapproved		1	l		F	:AUI	T CATE	GORY		L	<u> </u>	
Landing (	Gear				General							

ndir	g Gear	General			
	Bending	Bend	Grain	Ovalized Pressure/Force	∌d
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance Temperature/0	Jure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect Weld	
Ī	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing Wrong Stock P	ulled
	Cuffs	Contamination	Maintenance	Part Moved	
ſ	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other	
ſ	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
Ī	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

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Nork Order	DISPOSITION	AGAINST DEPARTMENT/PRO	OCESS	
NCR. Tes / NO	WORK ONDER HOW COM ON	QA Closed:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORM	MANCE / LIPDATE		
•		DQA:	Date:	

Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS					
WOIK OIU	-			<del>-</del> -		Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-			<del></del>		Use-as-is	<b>1  </b> т	herm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR f	No.					Work Order Update			Large Fab	Composite		Supplier	
												· I	
Root				ļ	1	ption of work order update	Initi	- 1		ction	Sign &	, <u></u>	
Cause		Date	Step	Qty	(	or Non-conformance	Chief	Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data	Ш		}										
Equip/Tooling	Ш							.					
Operator	Ц												
Material	Ш							.					
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Process	Ш			ļ ·				,					
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Training	Ш						ì	¥ .					
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	Ш	Bending				Bend	☐ Gr	rain -			Ovalized	~ _	Pressure/Forced
		Centre No	of Conce	ntric to	o/s	BOM/Route	На	irdwa	re		Over/Under	tolerance	Temperature/Cure
. `		Cracks	SEC.			Broken/Damaged	Ins	specti	on Incomplete		Pàrt Incorre	ct	Weld .
		Crushed/	Crimped			Burrs	Ins	struct	ions Incomplete,	/Unclear	Part Löst/M	issing *	Wrong Stock Pulled
		Cuffs				Contamination	M	ainte	nance	1	Part Moved	-	<del>-</del> .
	$\lceil . \rceil$	Heat Trea	it	1.46		Countersink	Mi	islabe	led		Positioned \	Wrong	- 1
		Inspection	n Strip in	Tube		Cut Too Short	Mi	isread	ī	<b>5</b> ·	Power Loss,	/Surge	Other
`* .	14	Ripples in	Bend	당.		Drill Holes	Off	fset					
	П	Torque W	/aves in l	xtrusio	n 🗀	Drawing	Ou	ut of C	Calibration				
*	$\square$	Turning S	equence	-₹°		Finish	Ou	ut of S	equence				**
ا حريه	1	Wave/Ťw	ist in Tul	e e		Folio	Пои	utside	Dimensions				